Work Order ID 56787 Page 1 Wednesday, March 10, 2010 8:36:53 AM Setup Start Accept D3609-1 Item ID: Revision ID: Stop Item Name: Doubler Start Qty: 6.00 Cust Item ID: 3/10/2010 Start Date: Required Date: 3/12/2010 Req'd Qty: 6.00 Customer: Reference: Start Run Process Plan: MF Date: 10-3-10 Tooling: Date: Approvals: Stop SPC (Y/N): Date: QC: Date: Reject Reject Insp. Accept Draw Draw Plan Operation Set Up/ Sequence ID/ Stamp Qty Qty Number Number Rev. Code **Run Hours** Description Work Center ID Revision Nbr Draw Nbr mer nor pulies Rev A D3609 0.00 100 HB 10-3-10 FLOW WATER JET 0.00 Waterjet Memo Prog Rev: A 2-1-Cut as per Dwg D3609 □Dwg Rev: FLOW CNC Waterjet Deburr if necessary 0.00 QC2-Inspect parts off machine FAI/FAIB 110 1B 10-3-10 0.00 QC Memo Quality Control 0.00 QC8- Inspect parts - second check 120 2 10/05/10 0.00 Memo Quality Control

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W/O:			WO	RK ORDER CHANGES	5			
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No);	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA:	Date: _	
	Reso	olution:	Disposition	:	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR	1)		
DATE	CTED	Description of NC		Corrective Action Section		Verification	Approval	Approva QC Inspecto
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	

Work Order ID 56787

Wednesday, March 10, 2010 8:36:53 AM



Page 2

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D3609-1

Accept

Setup Start

Revision ID: Item Name:

Doubler

Start Date:

3/10/2010

QC:

Start Qty: 6.00

Required Date: 3/12/2010

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop

Reject

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

Run Hours 0.00

Set Up/

0.00

Draw Number

Draw Rev.

Plan Accept Qty Code

Reject Qty

Number

Insp. Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart Aerospace Ltd W/O: WORK ORDER CHANGES Approval Approval DATE STEP PROCEDURE CHANGE Bv Date Qtv Chief Eng / Prod Mgr QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Description of NC Verification Approval Approval DATE STEP **Action Description** Sign & Initial Section A Section C Chief Eng QC Inspector Chief Eng Date Chief Eng

Picklist Print

Wednesday, March 10, 2010 8:36:52 AM

Work Order ID: 56787

D3609-1 Parent Item:

Parent Item Name: Doubler

Comments:

IPP Rev:A New Issue 07-03-26 JLM

IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC



Start Date: 3/10/2010

Start Qty: 6.00

Required Date: 3/12/2010

Required Qty: 6.00

Component Item ID/ Item Name M304S22GA

Replacement Mfg/ Item ID

Purch Purchased

Primary Item Location No

Last Location

Route Seq ID 100

Unit of Qty on Measure Hand sf 34.3500

Remaining Qty To Pick 7.4331

Qty Issued Date Issued

Status

Page 1

Loc Code

1B 10-3-10

Warehouse Loc Qty Location Main Warehouse MAT 34.35 109023 32.45 109088 1.9 109057

109057

304/316 .032 Sheet

Dart Aerospace Ltd W/O: WORK ORDER CHANGES Approval Approval STEP DATE PROCEDURE CHANGE By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Description of NC Verification Approval Approval DATE STEP Initial **Action Description** Sign & Section A QC Inspector Section C Chief Eng Date Chief Eng Chief Eng

Work Order:	56787
Part Number:	0 3609-1
	Page 1 of 1
	Work Order: Part Number:

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$ 698	4.004:061	.100	×	b		
13.56	4 .030	13.56	4	-		
12.38	4L 030	10:38	X	1		
13,69	4 .030	13.69	7			
,500	4/ 1010	-501	6			
1.259	41 -010	1.758	7			
,506	4 ,010	, 561	4			
,032	-L .00	P60.	8			
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			-	-	1	
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			-			
			-	-	1	
				1		
				-		
			1			
				-		

					3	

Measured by: Audited by:		
	Date:	N/A
Date: 10-3-10 Date: 10/03/10		

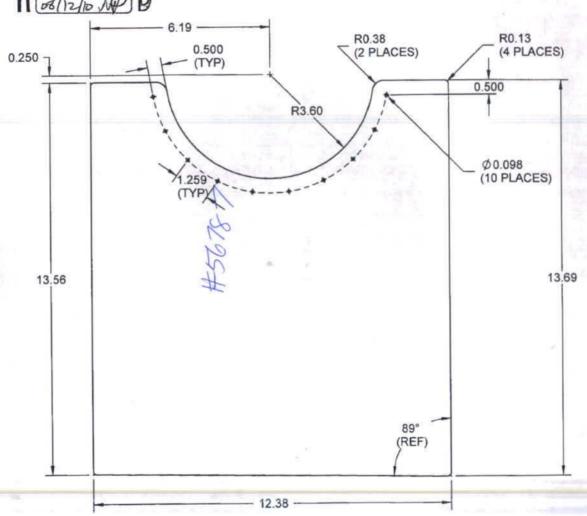
			Revised by	Approved
Rev	Date	Change	KJ/JLM	
A		New Issue		

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RELEASED MEDICAL DELLE ASED



D3609-1 DOUBLER

NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S22GA)

2) FINISH: NONE

- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) IDENTIFY WITH DART P/N "D3609-1" USING FINE POINT PERMANENT INK MARKER
 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
 7) PART IS SYMMETRIC ABOUT ©

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Dart Aerospace L	td
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W/O:			WO	RK ORDER CHANG	ES				
DATE STEP		PRO	OCEDURE CHAP	NGE	By Date Qt				Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
Resolution:			Disposition	Disposition: Q/			QA: N/C Closed: Date		
NCR:	170		WORK ORDE	R NON-CONFORM	ANCE (NCR	1)			
DATE	STEP	Description of NC Corrective Action			ction B Verifica			on Approval	Approval
	0.2	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector